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D4776-3
Job Sheet 187982



Part No: D4776-3

Job Qty: 20 ea

Part Name: Skidtube Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/29/18

Job Tracking No:

Due Date: 12/31/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG D4776 REV:E IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP REV:B 13.09.26 AS PER REV:B DD VERF:JLM IPP REV:C AS PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	12/31/18	12/31/18	0.00	0.00	Start Up Machining-3		DAS 19/1/19
100	Bandsaw	20 pcs	12/31/18	12/31/18	0.00	0.36	Bandsaw1		52
110	CNC Vertical Machining	20 pcs	12/31/18	12/31/18	0.26	17.39	HAAS1-5		9.89
120	QC	20 pcs	12/31/18	12/31/18	0.00	0.00	QC2 Machining-3		
130	QC	20 pcs	12/31/18	12/31/18	0.00	0.00	QC8 Machining-3		19/01/19
140	HandFinish	20 pcs	12/31/18	12/31/18	0.00	0.53	HandFinish1		D.R. 19/01/19
150	QC	20 pcs	12/31/18	12/31/18	0.00	0.00	QC7-4		38
160	Powdercoat	20 pcs	12/31/18	12/31/18	0.00	0.24	Powdercoat1		BK 19-01-22
170	QC	20 pcs	12/31/18	12/31/18	0.00	0.00	QC3		38
180	Packaging	20 pcs	12/31/18	12/31/18	0.00	0.00	Packaging3-2	5.115	JAN 2 8 2019
190	QC21-SA	20 Ea	12/31/18	12/31/18	0.00	0.00	QC21		JAN 2 8 2019

Part Op 100 - Cut Blank at 4.400" 4.625 as per folio
 Descriptions: 110 - 1-Machine per folio FB168 DWG REV: E FOLIO REV: EA 2- deburr and break all sharp edges
 160 - START TIME: 11:50 OVEN TEMPERATURE: 320° FINISH TIME: 12:00

M 138997

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	7.7200 ft (.386 ea)	90-Start up Operation	5/124463

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.500X2.500	8	0	0



Container No: S146057



Part: D4776-3

Job No: 187982

Serial No/Batch: S146057

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

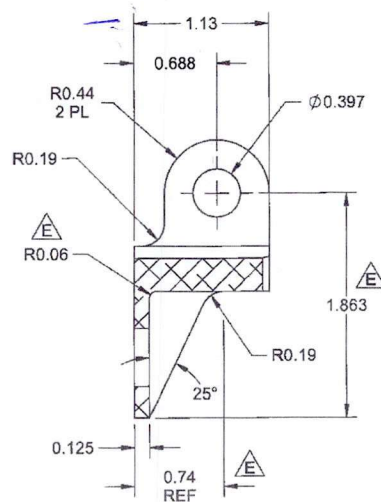
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Date: 01/19/19

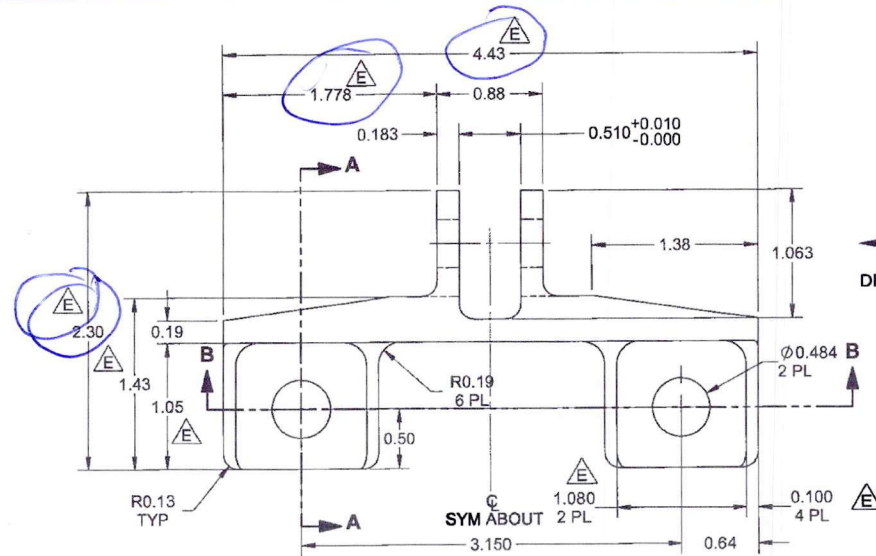
Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Skidtube Clevis 4.43	4.250Inches $\pm$ 0.030	4.280 4.220		
2	Skidtube Clevis 2.30	2.250Inches $\pm$ 0.030	2.280 2.220		
3	Skidtube Clevis 1.778	1.688Inches $\pm$ 0.010	1.698 1.678		
4	Skidtube Clevis	0.880Inches $\pm$ 0.030	0.910 0.850		
5	Skidtube Clevis	0.510Inches $\pm$ 0.010 - 0.000	0.520 0.510		
6	Skidtube Clevis	1.063Inches $\pm$ 0.010	1.073 1.053		
7	Skidtube Clevis	1.380Inches $\pm$ 0.030	1.410 1.350		
8	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160		
9	Skidtube Clevis 0.100	1.000Inches $\pm$ 0.030	1.030 0.970		
10	Skidtube Clevis	0.484Inches $\pm$ 0.006 - 0.001	0.490 0.483	Diameter	
11	Skidtube Clevis	0.500Inches $\pm$ 0.030	0.530 0.470		
12	Skidtube Clevis 0.664	0.550Inches $\pm$ 0.030	0.580 0.520		
13	Skidtube Clevis	3.150Inches $\pm$ 0.010	3.160 3.140		
14	Skidtube Clevis	1.130Inches $\pm$ 0.030	1.160 1.100		
15	Skidtube Clevis	0.688Inches $\pm$ 0.010	0.698 0.678		
16	Skidtube Clevis	0.397Inches $\pm$ 0.006 - 0.001	0.403 0.396	Diameter	
17	Skidtube Clevis 1.863	1.813Inches $\pm$ 0.010	1.823 1.803		
18	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160	Radius	
19	Skidtube Clevis	0.130Inches $\pm$ 0.030	0.160 0.100	Radius	
20	Skidtube Clevis	0.440Inches $\pm$ 0.030	0.470 0.410	Radius	
21	Skidtube Clevis	0.125Inches $\pm$ 0.010	0.135 0.115		
22	Skidtube Clevis	0.380Inches $\pm$ 0.030	0.410 0.350		
23	Skidtube Clevis	0.750Inches $\pm$ 0.030	0.780 0.720		
24	Skidtube Clevis	0.250Inches $\pm$ 0.030	0.280 0.220	Radius	

Plex 12/29/18 6:16 PM dart.auclair.guillaume



SECTION A-A (E)



SYM ABOUT

SECTION B-B (E)

D4776-3 SKIDTUBE CLEVIS

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.1
- 7) WEIGHT: 0.20 lbs

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	JFS	D4776	SHEET 2 OF 3
APPROVED	VS	TITLE	SCALE
DE APPR.	DSW	BASKET STRUT MACHINED PARTS NTS	
DATE	18.09.12	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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RELEASED
2018 -12- 03
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